

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006580**Date Inspected:** 06-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhang Zhi Neng and Liu Zhongan			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower		

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as South Tower Lift 1 corner seam b/c. The weld designations reviewed are as follows:

Bay 10

1. SSD1-A164E/J-245A
2. SSD1-A111B/H-127A

Bay 11

FCAW welding of weld joint 43 located on PCMK WSD1-FCSAS3-2B/C.

Welder is identified as Mr. Dong Changxi (070046). ZPMC QC is identified as Mr. Zhang Zhi Neng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

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FCAW welding of weld joint 42 located on PCMK WSD1-FCSAS3-2B/C.

Welder is identified as Mr. Nie Baofeng (068864). ZPMC QC is identified as Mr. Zhang Zhi Neng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

SMAW welding of weld joint 76 located on WD1-A467-23M-2.

Welder is identified as Mr. Yang Zhaoyin (047470). ZPMC QC is identified as Mr. Zhang Zhi Neng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair.

Bay 10

FCAW welding of weld joint 8 located on SSD1-FDSA3-1C/C.

Welder is identified as Mr. Zhang Songlin (057266). ZPMC QC is identified as Mr. Liu Zhongan.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F-2.

FCAW welding of weld joint 27 located on SSD1-FDSA3-1C/C.

Welder is identified as Mr. Zhang Qiquan (057206). ZPMC QC is identified as Mr. Liu Zhongan.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F-2.

FCAW welding of weld joint 34 located on NSD1-FCSA3-1E/E.

Welder is identified as Mr. Jiang Xiufang (040338). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-2332-Tc-P5-F.

FCAW welding of weld joint 137 located on SSD1-TL5C/L.

Welder is identified as Mrs. Dong Yumei (054069). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P5-F-2.

FCAW welding of weld joint 136 located on SSD1-TL5C/L.

Welder is identified as Mrs. Dong Yuqin (053116). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P5-F-2.

FCAW welding of weld joint 34 located on SSD1-TL5F/L.

Welder is identified as Mr. Wang Kui (203977). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P5-F-2.

FCAW welding of weld joint 33 located on SSD1-TL5F/L.

Welder is identified as Mr. Ni Xiuba (040533). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P5-F-2.

SAW welding of weld joint 50A located on NSD1-A112B/H.

Welder is identified as Mrs. Liu Xiaoya (207745). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-2221-B-U3c-S-2.

SAW welding of weld joint 68A located on NSD1-A112B/H.

Welder is identified as Mrs. Shen Xiaoquan (203981). ZPMC QC is identified as Mr. Tu Jun.

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The welding variables recorded by QC appeared to comply with WPS-2221-B-U3c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
